

**Work Order ID 70043**

Page 1

Wednesday, May 25, 2011 2:26:59 PM

Item ID: D206-802-030

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Opener Installation, RH

Start Date: 5/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*CL*

Date:

*11/05/25*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-3	A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-802-030 CHG001

*10 8/11/05/25**11/05/26*  
*(2)*

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*11/05/25*

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8/11/05/26**(2)*

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Page 2

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Accept



Setup Start



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Item Name: Crew Door Opener Installation, RH

Start Date: 5/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

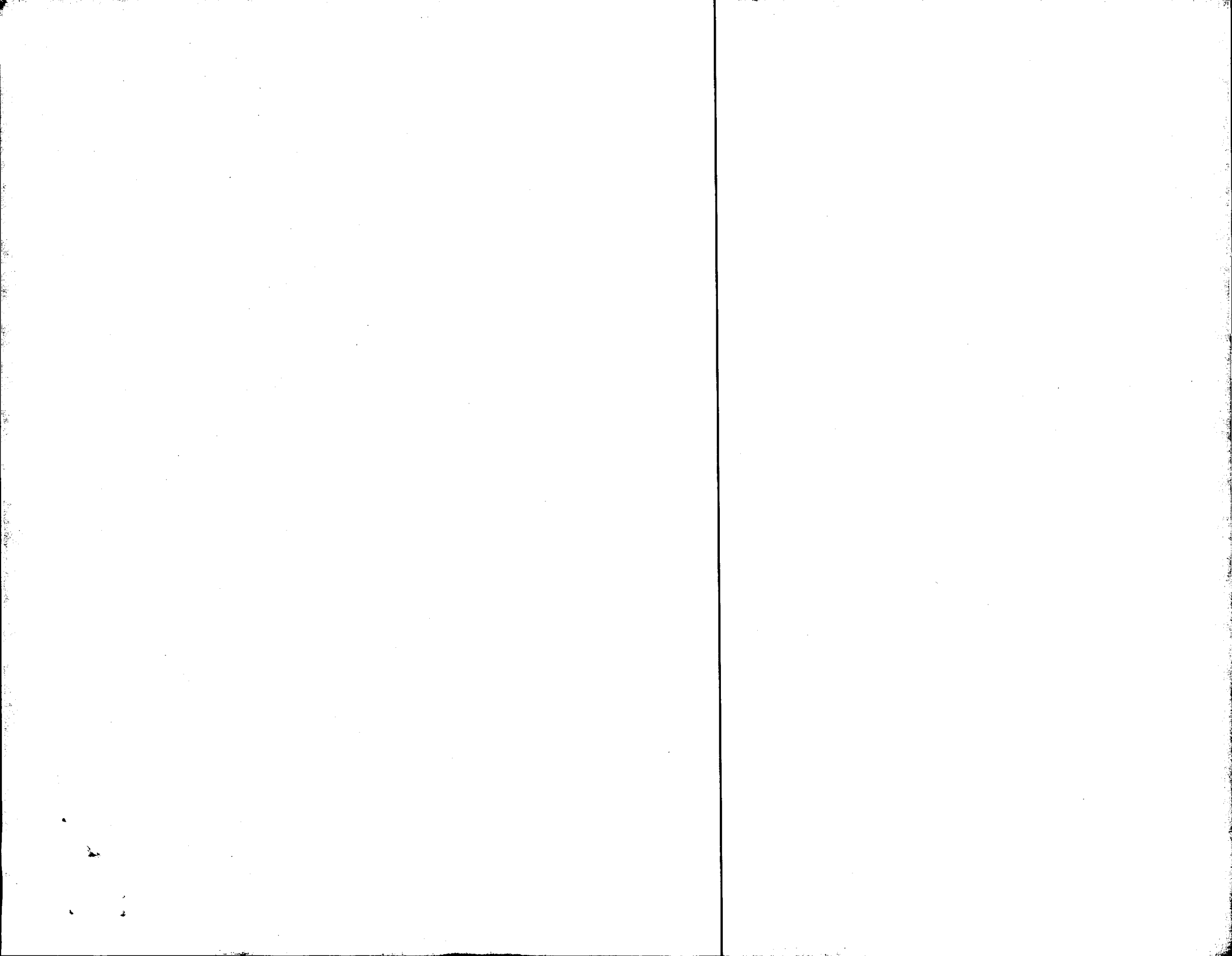


Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-030								
	Location: _____								
	PPP rev: _____								
	<i>DRAFT</i>								
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*11/10/26**11/15/30**UMF 11-05-26*



# Picklist Print

Wednesday, May 25, 2011 2:26:56 PM

Page 1

Work Order ID: 70043

Parent Item: D206-802-030

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 5/25/2011


Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-15		Manufactured	No			105	Each	27.0000	1	2	✓		
													
S <sub>2</sub> Door Prop													

Location	Loc Qty	Loc Code
----------	---------	----------

ST272	15	
64402	15	
ST272A	12	
65119	12	


64402

D3622-5		Manufactured	No			105	Each	48.0000	1	2	✓		
													
S <sub>2</sub> Ball Stud													

Location	Loc Qty	Loc Code
----------	---------	----------

ST070	48	
64330	8	
64428	20	
65087	20	


64330

D4110-3		Manufactured	No			105	Each	9.0000	1	2	✓		
													
S <sub>2</sub> Doubler, Sill													

Location	Loc Qty	Loc Code
----------	---------	----------

ST130	9	
64356	4	
64788	5	

64356

D4114-2		Manufactured	No			105	Each	0.0000	1	2	✓		
													
S <sub>2</sub> Door Doubler, RH													

64499

11/05/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 70043

Parent Item: D206-802-030

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 5/25/2011

Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

MS20426AD4-S Purchased No

105 Each

5,772.000

4

8



Rivet

## Location

## Loc Qty

## Loc Code

MEZZ

483

6733

483

ST317

5289

6874

5289

105

Each

300.0000

32

64

MS20600-AD4W2

Purchased

No



Rivet

## Location

## Loc Qty

## Loc Code

ST321

300

116391

5

116471

4

116805

35

117317

56

117601

150

117739

50

105

Each

141.0000

2

4

MS21073L5

Purchased

No



nut plate

## Location

## Loc Qty

## Loc Code

ST302

100

117395

100

ST303

41

113660

21

116583

20

6733

64

117317X56

116805X8

113660

JB

JB

JB 11/05/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 25, 2011 2:26:56 PM

Work Order ID: 70043

Parent Item: D206-802-030

Parent Item Name: Crew Door Opener Installation, RH

Start Date: 5/25/2011

Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0532R

Purchased

No

105

Each

324.0000

6

12

✓



WASHER

Location

Loc Qty

Loc Code

ST297

324

116289

24

116373

100

116513

200

116513

NAS1149C0563R

Purchased

No

105

Each

550.0000

6

12

✓



Washer

Location

Loc Qty

Loc Code

ST297

550

112532

100

115768

50

116391

200

117460

200

115768

MS27130-A26

Purchased

No

105

Each

77.0000

1

2

✓



Rivnut

Location

Loc Qty

Loc Code

ST293

77

116521

77

116521



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D206-802-3  
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## 5.0 PARTS LIST

### 5.1 D206-802-029/-030 Crew Door Opener Kits

Qty -029	Qty -030	Part Number	Description
		D206-802-029	CREW DOOR OPENER KIT, LH
		D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1	1	D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

### 5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER

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Revision: A  
Date: 10.10.13